

1. 49

SPLIT

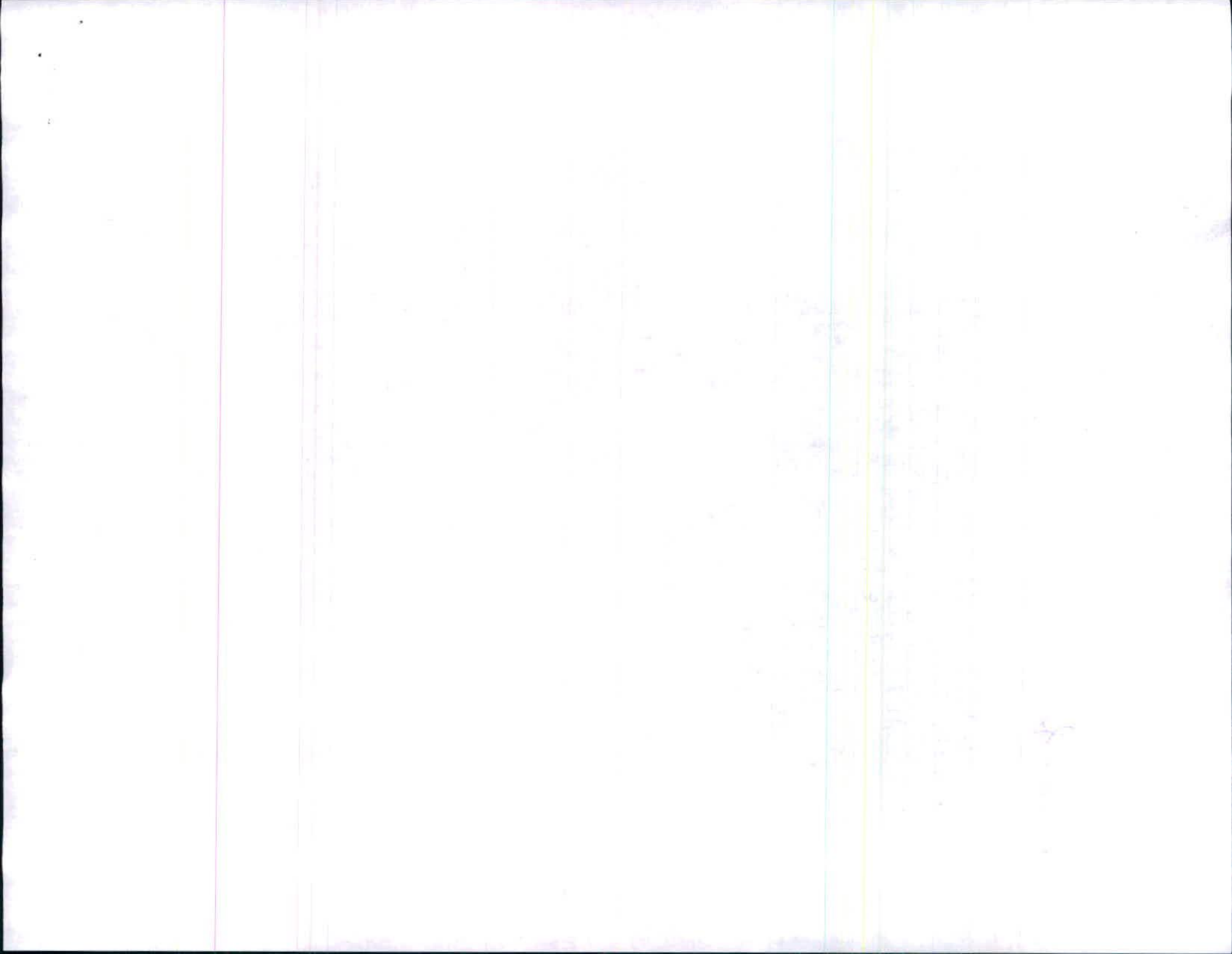
| | | |
|---|---------------------|----------------------|
| DART AEROSPACE LTD | Work Order: | 21843 |
| Description: Bearpaw Kit (23" x 19") | Part Number: | K10010 |
| Dwg: D2421 Rev. F1 <u>F2</u> | Qty: | 5 40 Kits |
| Ref: K10010 Rev. A; DSK086-4 Rev. A | | Page 1 of 1 |

| Step | Location | Procedure | By | Date | Qty | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|------|-------------------------------|---|-------------|-------------|-------------|-------|---|-----------|----------------|--------|---|-------|--------------|--------|---|-------|---------|--------|---|-------|-------|--------|---|-------|--------|---------|---|---------|------|--------|---|------------|--------|--------|---|-----------|-------------|--------|---|-----------|-------|-------------|---|-------------------------------|--|--|----|----------|----|
| 1 | DC | Issue Traveler Note: (1) K10010 Kit consists of Qty (2) D2421 Dwg not required | df | 04.11.02 | 5 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | DC | Photocopy bluefile: K10010 D900-619-011 D105-645-011 and create labels per PPP K10010 CHG003 (Bag Bluefiles separately) | df | 04.11.04 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3 | GA | Cut 2 blanks per (1) K10010 Kit Cut blank: 19.50" x 23.50" x 1.00" thick (+0.030/-0.000) per DSK086-4 Material: Black UHMW 1" (MUHMWB10) Batch: <u>m15926</u> | ML | 04/11/02 | 5 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 | MV | Inspect material for defects or damage prior to machining | ML | 04/11/02 | 5 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 5 | MV | Machine as per Folio FA124 and Dwg D2421 Identify as D2421 | ML | 04/11/03 | 3 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 6 | QC2 | Inspect parts as they come off the CNC machine | ML | 04/11/03 | 3 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 7 | MV | Deburr | ML | 04/11/03 | 3 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | QC8 & 5 | Second inspection | EN | 04/11/04 | 3 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 9 | KP | Pick: Packing Kit (Note: D2421 is on the BOM as material from step 3) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>4</td><td>D2182B060</td><td>Rubber Cushion</td><td>B21185</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B21585</td></tr><tr><td>2</td><td>D2421</td><td>Bearpaw</td><td>B21873</td></tr><tr><td>4</td><td>D2519</td><td>Clamp</td><td>B14649</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B21587A</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt</td><td>m15321</td></tr><tr><td>8</td><td>AN960JD416</td><td>Washer</td><td>m15321</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>m15020</td></tr><tr><td>4</td><td>QS100M24S</td><td>Clamp</td><td>m9523/m1721</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table> | Qty | Part Number | Description | Batch | 4 | D2182B060 | Rubber Cushion | B21185 | 8 | D2274 | Radius Block | B21585 | 2 | D2421 | Bearpaw | B21873 | 4 | D2519 | Clamp | B14649 | 8 | D2529 | Washer | B21587A | 8 | AN4-15A | Bolt | m15321 | 8 | AN960JD416 | Washer | m15321 | 8 | MS21042L4 | Nut (or -4) | m15020 | 4 | QS100M24S | Clamp | m9523/m1721 | 1 | Paperwork package from Step 2 | | | ML | 04-11-04 | 54 |
| Qty | Part Number | Description | Batch | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 | D2182B060 | Rubber Cushion | B21185 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | D2274 | Radius Block | B21585 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | D2421 | Bearpaw | B21873 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 | D2519 | Clamp | B14649 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | D2529 | Washer | B21587A | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | AN4-15A | Bolt | m15321 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | AN960JD416 | Washer | m15321 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | MS21042L4 | Nut (or -4) | m15020 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 | QS100M24S | Clamp | m9523/m1721 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1 | Paperwork package from Step 2 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 10 | QC4 | Inspect Kit for 100% Completeness on the W/O | ML | 04/11/04 | 54 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 11 | PK | Identify and pack for shipping as per PPP K10010 REV. B | ML | 04/11/05 | 4 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 12 | AC | Cost / part <u>213.08</u> | ML | 04-11-08 | 4 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 13 | DC | Close W/O <u>207.37</u> Inspect Level 21 | df | 04.11.10 | 4 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|---------------------------------------|------------|----------|
| A | 00.03.21 | K10010 created for Bearpaw (MPP 2037) | EC | |
| B | 03.05.26 | Reformat; Incorporated D2421 | KJ/RF | |
| C | 04.02.17 | Blank size changed on Step 3 | KJ/JLM | |

BB 04-11-08

RELEASED
04.02.20

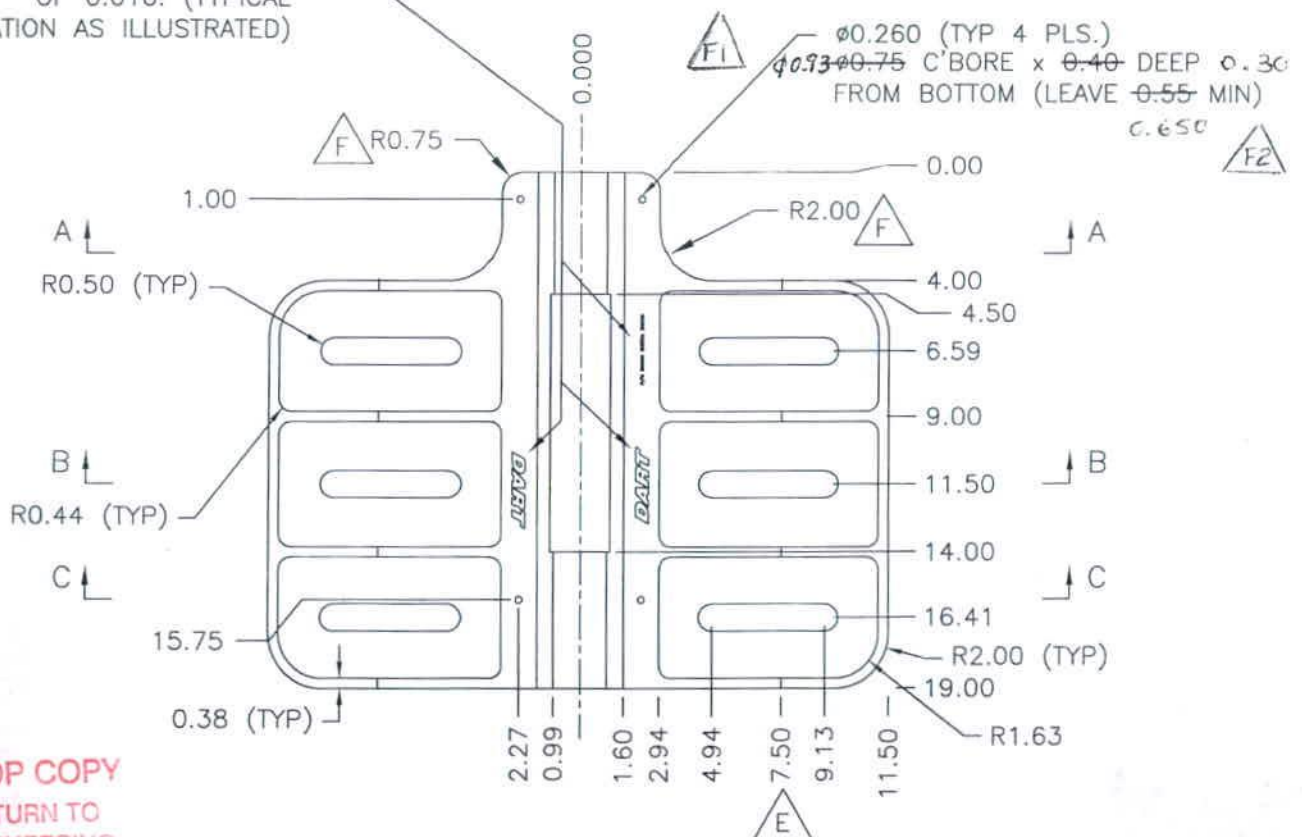


DART

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|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>RF</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2421 | REV. F SHEET 1 OF 2 |
| DATE 01.03.12 | | TITLE BEARPAW | SCALE 1:7 |
| A | 95.04.24 | NEW ISSUE | |
| B | 95.11.28 | CHANGED NUMBER OF HOLES | |
| C | 97.06.19 | ADDED MATERIAL SPECIFICATION | |
| D | 98.08.11 | DIM MODIFICATIONS | |
| E | 00.03.01 | R1.77 WAS R2.66; ADD R1.85 BORE RELIEF FOR CLAMPS; ADDED DEO 9155 | |
| F | 01.03.12 | MODIFY FWD END | |
| F1 | RF 03.01.13 | $\phi 0.93$ WAS $\phi 0.75$; R0.19 WAS R0.38; 0.19 WAS 0.25 | |
| F2 | RF 04.11.03 | 0.30 WAS 0.40; 0.650 WAS 0.55 | |

RELEASED
01.03.14 *[Signature]*

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



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WORK ORDER

NO. 21843 *B*

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689,
1.00" THICK (MACHINE TO 0.950)

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MOBK C. C.

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| CHECKED RF | APPROVED | DRAWING NO. D2421 | REV. F SHEET 2 OF 2 |
| DATE 01.03.12 | | TITLE BEARPAW | SCALE 1:6 |

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01.03.14 #

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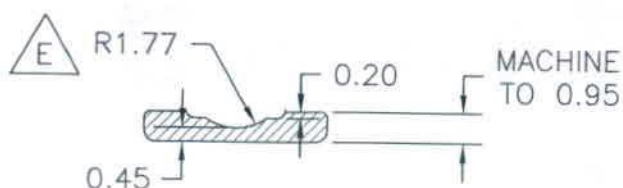
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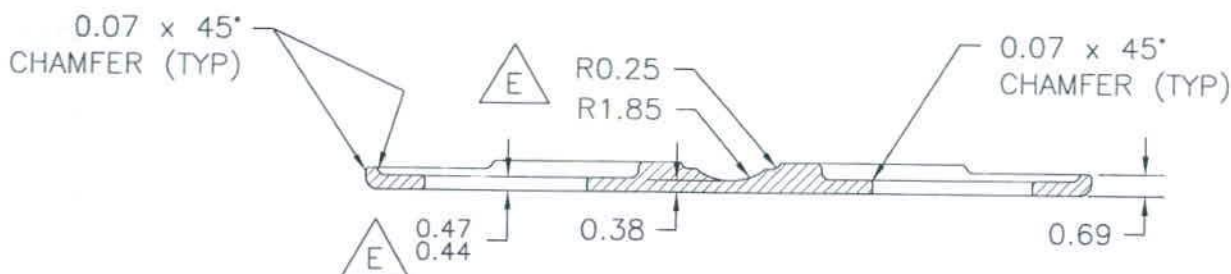
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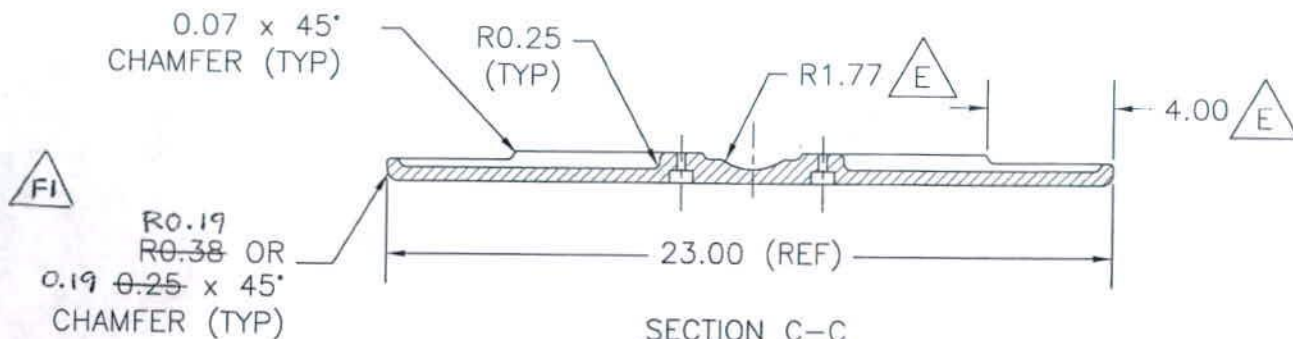
NO. 21843 B



SECTION A-A



SECTION B-B



SECTION C-C

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|-----------------------|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | | Work Order: | 21843 B |
| Description: Bearpaw | | Part Number: | D2421 |
| Inspection Dwg: D2421 | Rev: F1 F2 | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--|---------------|---------------------|--------|--------|-------------------------|----------|
| A 0.20 | +/-0.030 | 0.197 | ✓ | | Vern | |
| B 0.95 | +/-0.030 | 0.958 | ✓ | | Vern | |
| C 0.45 | +/-0.010 | 0.448 | ✓ | | Vern | |
| D 0.07 x 45° | +0.030/-0.010 | 0.06 x 45° | ✓ | | Vern | |
| E 0.69 | +/-0.030 | 0.695 | ✓ | | Vern | |
| F 0.38 | +/-0.010 | 0.378 | ✓ | | Vern | |
| G 0.44 - 0.47 | +/-0.000 | 0.448 | ✓ | | Vern | |
| H R0.25 | +/-0.030 | R0.25 | ✓ | | R-6 | |
| I 0.19 x 45° | +/-0.030 | 0.18 x 45° | ✓ | | Vern | |
| J 23.00 | +/-0.030 | 23.00 | ✓ | | M-Tapp | |
| K Ø0.260 | +0.005/-0.000 | Ø0.260 | ✓ | | Vern | |
| L Ø0.93 | +/-0.030 | Ø0.928 | ✓ | | Vern | |
| M 0.40 0.30 +/-0.030/-0.000 | | 0.305 | ✓ | | Vern | |
| N 4.50 | +/-0.030 | 4.50 | ✓ | | Vern | |
| O 9.50 | +/-0.030 | 9.50 | ✓ | | Vern | |
| P 1.00 | +/-0.030 | 1.00 | ✓ | | Vern | |
| Q 14.750 | +/-0.010 | 14.750 | ✓ | | MT-Tapie | |
| R 0.38 | +/-0.030 | 0.382 | ✓ | | Vern | |
| S 4.54 | +/-0.010 | 4.54 | ✓ | | Vern | |
| T 19.00 | +/-0.030 | 19.00 | ✓ | | M-Tape | |
| | | | | | | |
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|------------------------|-----------------------|---------------------|-----|
| Measured by: <i>ML</i> | Audited by: <i>EP</i> | Prototype Approval: | N/A |
| Date: 04/11/03 | Date: 04/11/03 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 03.09.22 | New Issue | KJ/RF | <i>[Signature]</i> |

RELEASED

RT 04.01.15

